

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028318**Date Inspected:** 30-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-OBG W12/W13 Drop-In Panel (Observation of excavations, repair welding, QC inspection and testing of side plate "C").

Rodney Patterson-OBG E13/E14 Drop-In Panel (Observation of excavations, repair welding, QC inspection, testing of deck plate splices and edge plate "G") and performed QA/VT, MPT & UT verification at various locations as requested by the contractor's QC Department. One (1) issue was noted on this day. See Summary of Conversations below.

Fritz Belford-OBG E12 (Observation of welding, QC inspection, testing of floor beams) and performed QA/VT and MPT verification at various locations as requested by the contractor's QC Department.

Matt Daggett-OBG W12 Corner Drop-In Ass'y (Observation of excavation, repair welding, QC inspection and testing of deck plate splices).

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William Clifford-Tower Shear Plates, ESW "E" performed QA/UT verification as requested by the contractor's QC Department and also performed a QA/QC joint inspection (UT) of ESW "W".

Doug Frey-OBG E12 Corner Drop-In Plate Ass'y (Observation of welding, QC inspection and testing of floor beams) and deck plate splices) and OBG E12 Corner Drop-In Ass'y (Observation of excavations, repair welding, QC inspection and testing of the deck plate splice) and performed QA/VT and MPT verification at various locations as requested by the contractor's QC Department..

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Rodney Patterson, Fritz Belford, Doug Frey and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications. There was one (1) issue noted during this shift.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies. This QA Lead Inspector also received and reviewed the following approved Request for Weld Repair (RWR) documents 201208-111 and 113. Also, received the current Submittal Log Update. All documents were received via e-mail.

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

There were also, other pertinent conversations with QA Supervisor, William Levell, throughout the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and weld issues. There was one (1) issue noted during this shift. See below:

This QALI and QAI Rodney Patterson observed the repair welding of the weld identified as 13E-PP122.2. At this time Mr. Patterson noted that the incorrect WPS was utilized to perform this welding task. At this time Mr. Patterson brought this issue to the attention of the QALI. Upon the conclusion of this QALI review of the RWR documentation identified as 201208-105 this QALI noted that the welding was not per the approved RWR. The issue at hand is the incorrect weld process was used. NOTE: process utilized is FCAW-G instead of SMAW as noted in the approved RWR. In conclusion this QALI generated the IR and was forwarded to the QA Task Leader, William Levell, for his review and disposition.

This QALI also met with Eric Blue, ABF Field Engineer in regards to updating the ABF generated spread sheet

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regarding status of the east end OBG's. This spread sheet is designed to provide tracking information regarding the scheduling of the load transfer of the SAS bridge.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
